

Date: Wednesday, 1/11/2006 4:30:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 25483		
Estimate Number	: 10104		
P.O. Number	: N/A	Part Number	: D2012107
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Number	: D2012-107 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/31/2006 Qty: 100 Um: Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est: D 01.11.08 Re-format, Drawing to Rev. C SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: 377	
	E-mail or Ship DXF file to vendor	U
	Laser cut flat pattern as per DXF File	06.01.12
	Material realease note is required.	100
2.0	D2012107F	Clevis
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)	
	CLEVIS	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 17 Date: 06/02/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLEVIS

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Part Number: D2012107

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

DL 06/02/08 (110)

7.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 16

C 06/02/09 (110)

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/02/13 (110)

(110) 06/02/10

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

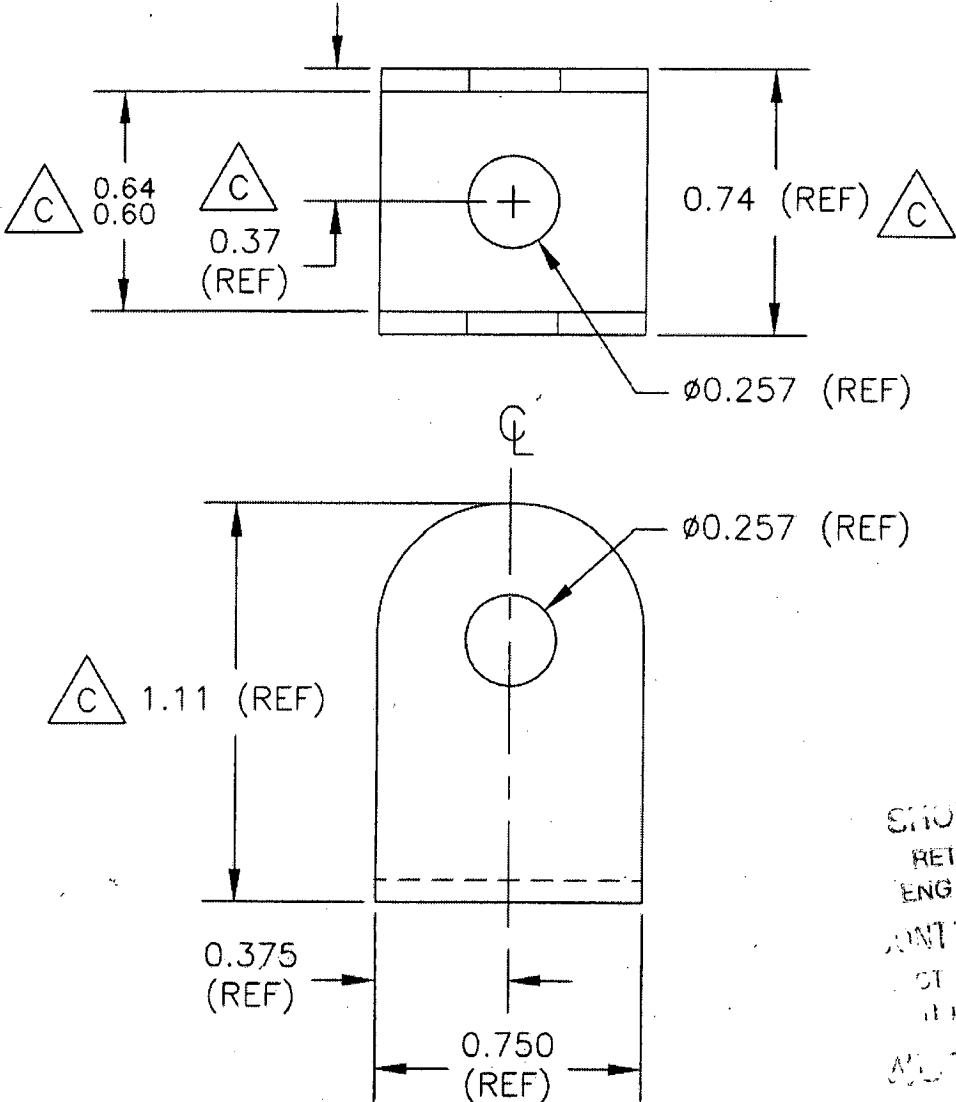
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107
		REV. C
DATE 99.12.20	TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE
B	99.04.30	ADD FLAT PATTERN
C	99.12.20	0.74 WAS 0.680

RELEASED
00.01.04 DS

MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS

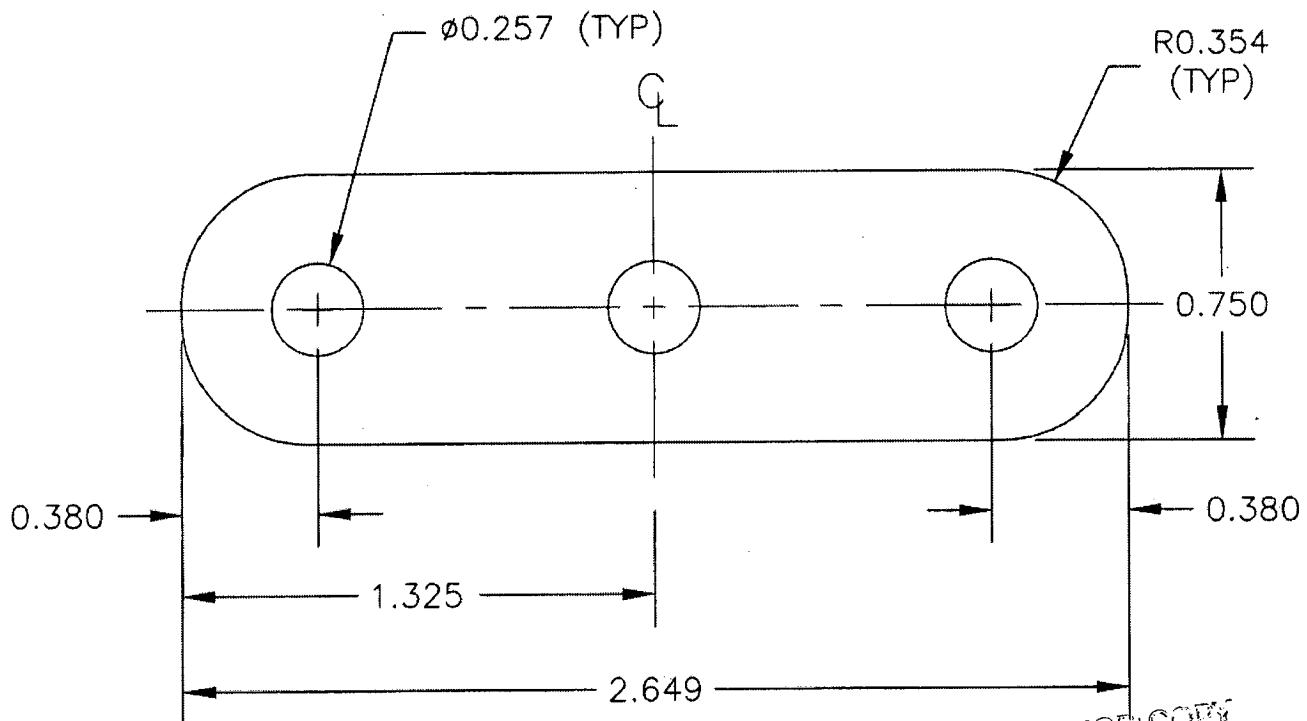
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



ISSUED
OCT 2004

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2012-107
DATE 99.12.20	TITLE CLEVIS	REV. C SHEET 2 OF 2 SCALE 2:1

RELEASED
00-01-04 DS



D2012-107 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITH

W/C

25483

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

10/22/2004 07:18 FAX 306 65

88

WILKINSON STEEL & METALS

007/009

OCT-21-2004 15:58

MARUBENI-ITOCHU STEEL

604 669 0529 P.07/09



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I.

Paragraph 4.3 by TÜV Anlagetechnik GmbH (Notified Body Identification No.0035)

Inspection Certificate EN10204-3.1B

Taiyuan Iron and Steel(Group)Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China
 TEL: (0351)3013328 FAX: (0351)3017816
<http://www.tisco.com.cn>
 E_email: tgbxg@tisco.com.cn

INSPECTION CERTIFICATE

MATERIAL	AISI304 No.2B Finish
SPECIFICATION	ASTM A240/A480-02 ASME SA240/SA480
L/C NO.	
CERTIFICATE NO.	20040941
DATE OF ISSUE	/ /

CUSTOMER
 Marubeni-Itochu Steel Co.

CONTRACT NO.
 P40824PC001

DATA OF
 2004/09/20

Product	Melting furnace	Inspectors stamp		Mark of the Manufacturer
COIL	E+VOD	Shanxi Taiyuan Stainless Steel Co.,ltd		
NO.	Heat No.	Coil No.	Quantity	Dimensions
1	4402727	4A7-310-4ZJ	1	0.0461 × 48 × C
2	4402727	4A7-309-4ZJ	1	0.0461 × 48 × C .0500
3	4402738	4A7-373-4ZY	1	0.0461 × 48 × C
4	4402925	4A8-118-4ZD	1	0.0721 × 48 × C
5	4402924	4A8-116-4ZY	1	0.0721 × 48 × C .0780
6	4402933	4A8-154-3ZB	1	0.0721 × 48 × C
7	4402923	4A8-157-3ZB	1	0.0981 × 48 × C .1090

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4402727	0.050	0.450	1.370	0.022	0.002	18.070	8.120				
4402727	0.050	0.450	1.370	0.022	0.002	18.070	8.120				
4402738	0.050	0.460	1.360	0.019	0.002	18.100	8.100				
4402925	0.060	0.470	1.390	0.019	0.002	18.180	8.130				
4402924	0.060	0.480	1.380	0.019	0.002	18.180	8.130				
4402933	0.050	0.520	1.440	0.019	0.003	18.160	8.020				
4402923	0.050	0.460	1.340	0.020	0.004	18.140	8.210				

Mechanical Properties

Test No.	Tensile R_m N/mm ²	R _{E0.2} Yield _{0.2%} N/mm ²	R _{P0.5} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4402727-T	655	270		66		86		
4402727-T	655	270		66		86		
4402738-T	650	255		66.5		86		
4402925-T	630	235		60		86		
4402924-T	635	235		63		85		
4402933-T	630	245		66.5		82		
4402923-T	650	265		57.5		85		

Surface and dimensions controlled: O.K.

Work Inspector: *ZG-V-SG*

P/D 377

Page: 1 of 2

P40824PC001.

J Abor-AB

16ga 304 2B S.S

